

Work Order ID 77432

77432

Ship Eagle

Page 1

Item ID: D412-761-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Modified Latch Mechanism, LH

Stop *NS2*

Start Date: 12/7/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/12/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MF

Date: 11-12-09 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

DSI9580

A

IIN D412-761

Rev D

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-761-043 CHG001

Switz/14

11-12-12

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 77432***77432***

Page 2

Wednesday, December 07, 2011 7:27:06 AM

Item ID: D412-761-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Modified Latch Mechanism, LH

Start Date: 12/7/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/12/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

130

Packaging

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-761-043

Location: _____

PPP Rev: A

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

(X2)11/12/14 SP/2011/12/14
MF
11-12-14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Wednesday, December 07, 2011 7:27:06 A

Page 1

Work Order ID: 77432

Parent Item: D412-761-043

Parent Item Name: Modified Latch Mechanism, LH

Start Date: 12/7/2011

Required Date: 12/12/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 09-01-13 rev.C as per dwg DD verified by:EC IPP REV:B 11.11.29 AS PER
DSI9580 DD VERF:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| Spr D3589-041 LATCH ASSEMBLY | | Manufactured | No | | | 110 | Each | 0.0000 | 1 | B77333 | | | |
| Spr D3589-047 FWD GUIDE | | Manufactured | No | | | 110 | Each | 0.0000 | 1 | B 77334 | | | |
| Spr D3589-049 Aft Guide | | Manufactured | No | | | 110 | Each | 0.0000 | 1 | B77335 | | | |
| Spr MS16997-24 SCREW | | Purchased | No | | | 110 | Each | 28.0000 | 2 | 4 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST314 | | 28 | | | | 119811 | | | |
| Spr AN960JD6L Washer | | Purchased | No | | 119811 | 28 | Each | 828.0000 | 2 | 4 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST337A | | 828 | | | | 5519 | | | |
| Spr MS21042L06 Nut | | Purchased | No | | 5519 | 828 | Each | 212.0000 | 2 | 4 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST300 | | 212 | | | | 118686 | | | |
| | | | | 118354 | | 2 | | | | | | | |
| | | | | 118686 | | 10 | | | | | | | |
| | | | | 119109 | | 100 | | | | | | | |
| | | | | 119307 | | 50 | | | | | | | |
| | | | | 119758 | | 50 | | | | | | | |

11/12/12 (2)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

5.0 PARTS LIST, FULL VERTICAL REFERENCE DOOR MOD

| QTY -041 | QTY -043 | QTY -045 | QTY -047 | QTY -049 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|-------------|--------------|---------------------------------------|
| X | | | | | D412-761-041 | FULL VERTICAL REFERENCE DOOR KIT, LH |
| | X | 1 | | | D412-761-043 | MODIFIED LATCH MECHANISM KIT, LH |
| 1 | | X | | | D412-761-045 | LARGE BUBBLE WINDOW KIT, LH |
| 1 | | | X | | D412-761-047 | DOOR MOUNTED INSTRUMENT PANEL KIT, LH |
| 1 | | | | X | D412-761-049 | ARMREST KIT, LH |
| | 1 | | | | D3589-041 | LATCH ASSEMBLY |
| | 1 | | | | D3589-047 | FORWARD GUIDE |
| | 1 | | | | D3589-049 | AFT GUIDE |
| | 2 | | | | MS16997-22 | SCREW |
| | 2 | | | | AN960JD6L | WASHER |
| | 2 | | | | MS21042L06 | NUT |
| | | 1 | | | D3676-1 | LARGE BUBBLE WINDOW |
| | | 1 | | | D3678-1 | PLACARD |
| | | 1 | | | D3678-3 | PLACARD |
| | | 1 | | | D3700-1 | INBOARD WINDOW DOUBLER |
| | | 1 | | | D3700-3 | OUTBOARD WINDOW DOUBLER |
| | | 1 | | | D3701-1 | FLOOR DOUBLER |
| | | 1 | | | D3702-1 | FORWARD DOUBLER |
| | | 1 | | | D3703-1 | AFT DOUBLER |
| | | 1 | | | D3703-3 | AFT CORNER DOUBLER |
| | | 1 | | | D3703-5 | AFT CAP |
| | | 1 | | | D3704-1 | ESCUTCHEON |
| | | 1 | | | D3704-3 | ESCUTCHEON |
| | | 1 | | | D3708-1 | ANGLE |
| | | 1 | | | D3708-3 | ANGLE |
| | | 1 | | | D3709-1 | ANGLE |
| | | 1 | | | D3709-3 | ANGLE |
| | | 1 | | | D3802-1-135 | SEAL |
| | | 1 | | | DT9458 | CUTTING TEMPLATE |
| | | 26 | | | AN3-7A | BOLT |
| | | 52 | | | AN960JD10 | WASHER |
| | | 26 | | | MS21042L3 | NUT |
| | | 1 | | | MS24694-C5 | SCREW (OR MS24694-S5) |
| | | 1 | | | MS24694-C13 | SCREW (OR MS24694-S13) |
| | | | 1 | | D3705-041 | INSTRUMENT PANEL ASSEMBLY |
| | | | 1 | | D3705-043 | * INSTRUMENT PANEL WELDMENT |
| | | | 1 | | D3335-1 | * SPRING |
| | | | 1 | | D3705-5 | * ACCESS PANEL |
| | | | 1 | | D3706-5 | * PIN |
| | | | 2 | | D3707-3 | * MOUNTING LUG |
| | | | 4 | | AN526C1032R6 | * SCREW |
| | | | 1 | | AN960JD516 | * WASHER |
| | | | 1 | | MS171498 | * SPRING SLOTTED PIN |
| | | | 4 | | MS24693-C272 | * SCREW (OR MS24693-S272) |

*DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

(CONTINUED ON PAGE 9)

(CONTINUED FROM PAGE 8)

| QTY -041 | QTY -043 | QTY -045 | QTY -047 | QTY -049 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|-------------|------------------|------------------------------------|
| | | | 2 | | D3707-1 | MOUNTING LUG |
| | | | 1 | | D3790-1 | INDEXING BLOCK |
| | | | 1 | | D3867-1 | CONNECTOR PLATE |
| | | | 4 | | AN3-3A | BOLT |
| | | | 6 | | AN526C1032R6 | SCREW |
| | | | 2 | | AN743-12 | BRACKET |
| | | | 6 | | AN960JD10L | WASHER |
| | | | 6 | | MS21075L3 | NUTPLATE (OR MS21073-3) |
| | | | 4 | | MS24693-C272 | SCREW (OR MS24693-S272) |
| | | | 1 | | MS27039-1-17 | SCREW |
| | | | 1 | | MS27039-1-27 | SCREW |
| | | | 4 | | MS21042L3 | NUT |
| | | | 2 | | MS21919WDG8 | CLAMP |
| | | | | 1 | D3694-041 | MOUNTING PLATE ASSEMBLY |
| | | | | 1 | D3694-1 | * KEYWAY |
| | | | | 1 | D3694-3 | * PROTECTIVE PLATE |
| | | | | 1 | D3694-5 | * MOUNTING PLATE |
| | | | | 1 | AN526C1032R8 | * SCREW |
| | | | | 5 | AN960JD10 | * WASHER |
| | | | | 4 | MS21042L3 | * NUT |
| | | | | 2 | MS21209F1-20 | * HELI-COIL, SCREW LOCKING (RED) |
| | | | | 1 | MS24693-C271 | * SCREW (OR MS24693-S271) |
| | | | | 4 | MS24693-C273 | * SCREW (OR MS24693-S273) |
| | | | | 1 | D3695-041 | SLIDER ASSEMBLY |
| | | | | 1 | D3695-1 | * SLIDER |
| | | | | 1 | D3695-3 | * STOPPER |
| | | | | 1 | D3801-1 | * HAND RETRACTABLE SPRING PLUNGER |
| | | | | 1 | MS21209F6-25 | * HELI-COIL, SCREW LOCKING (RED) |
| | | | | 4 | MS21209F1-20 | * HELI-COIL, SCREW LOCKING (RED) |
| | | | | 4 | MS24693-C276 | * SCREW (OR MS24693-S276) |
| | | | | 1 | D3780-041 | ARMREST ASSEMBLY |
| | | | | 1 | D3696-041 | * ARM ASSEMBLY |
| | | | | 1 | D3696-1 | ** ARM |
| | | | | 1 | D3801-3 | ** HAND RETRACTABLE SPRING PLUNGER |
| | | | | 1 | D3781-041 | * LATERAL CUSHION ASSEMBLY |
| | | | | 1 | D3781-043 | * ARMREST CUSHION ASSEMBLY |
| | | | | 1 | D3785-3 | * BRACKET |
| | | | | 1 | D3977-1 | * BOLT |
| | | | | 1 | D3978-1 | * NUT (CASTELLATED) |
| | | | | 1 | D3979-1 | * WASHER (SQUARE HOLE) |
| | | | | 2 | AN970-6 | * WASHER |
| | | | | 1 | MS24665-302 | * COTTER PIN |
| | | | | 2 | MS21042L3 | * NUT |
| | | | | 2 | MS24693-C272 | * SCREW |
| | | | | 2 | MS24693-C277 | * SCREW |
| | | | | 1 | NAS1149D0663J | * WASHER |

* DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

(CONTINUED ON PAGE 10)

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Revision: D

Date: 09.06.18

(CONTINUED FROM PAGE 9)

| QTY -041 | QTY -043 | QTY -045 | QTY -047 | QTY -049 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|-------------|-------------|-----------------|
| | | | | 11 | AN3-6A | BOLT |
| | | | | 1 | AN6-26 | BOLT |
| | | | | 1 | AN310-6 | CASTELLATED NUT |
| | | | | 11 | AN960JD10 | WASHER |
| | | | | 1 | AN960JD616L | WASHER |
| | | | | 2 | NAS1515H6L | WASHER |
| | | | | 1 | MS24665-302 | COTTER PIN |
| | | | | 3 | MS21071L3 | ANCHORNUT |
| | | | | 8 | MS21075L3 | NUTPLATE |

6.0 PARTS LIST, OPTIONAL VENT KIT

| QTY -141 | PART NUMBER | DESCRIPTION |
|-------------|--------------|-------------|
| X | D412-761-141 | VENT KIT |
| 4 | D3932-1 | SNAP VENT |